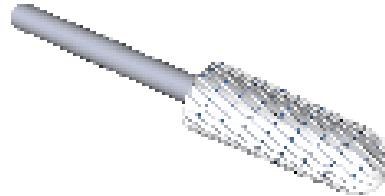







Burr Ø1.2 Z8 with radius

A11-025

The tapered burr Ø1.2mm is ground from a solid carbide blank. The requested geometry of all 8 teeth is achieved with a 1V1 wheel.



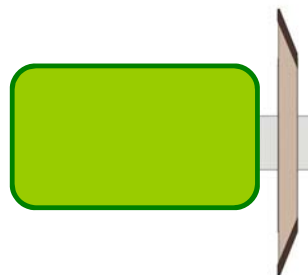
1. Cycletime for Production

Workpiece: D 1.2 mm, Z 8, L4.1 mm, H 6°, Nr. of threads 11 Material CARBIDE			
Operations			
Feed [mm/Min]	2000	400	800
Power [kW]		1	1
Cutting speed [m/s]		19	19
Used wheels			
Grinding time [s]	10	1	2
Total cycle time	3 Min 10 Sec		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1V1 Ø60 D30
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3. Machine and Software Requirements

Machines: 5 axes CNC grinder : Aries, Norma, NGC Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31i Software: Quinto 5

Accessories:

Responsible engineer: SIW. 12.2014

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